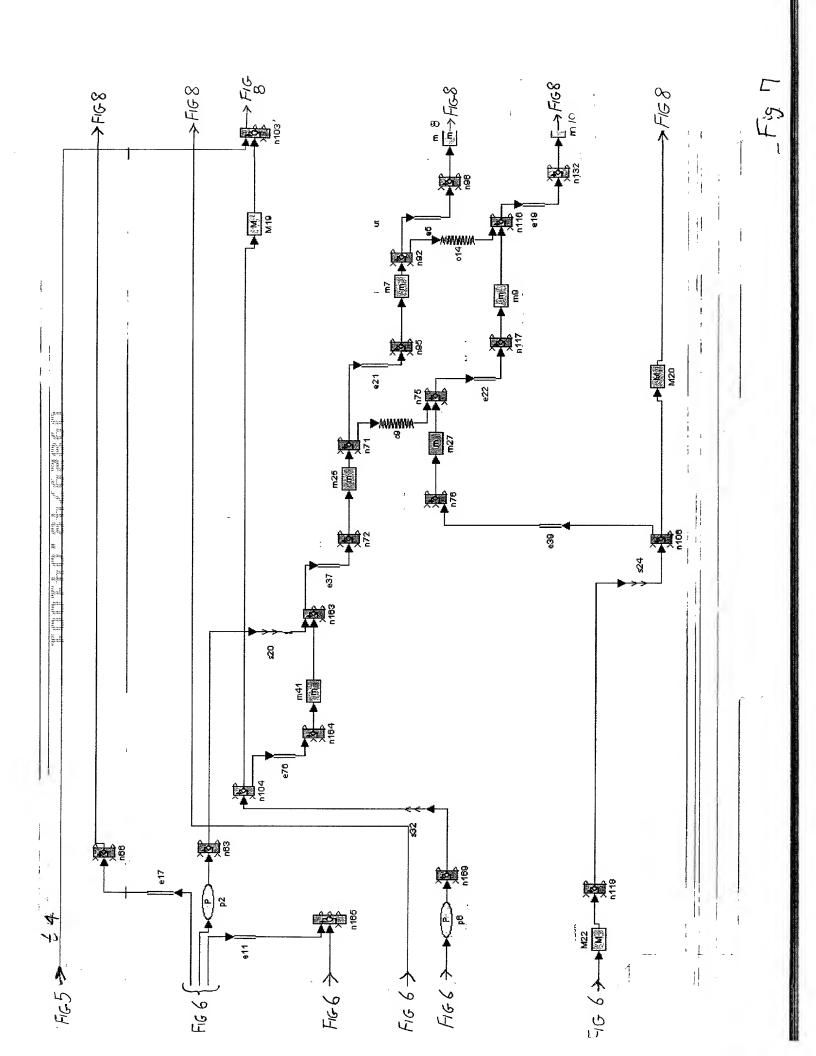
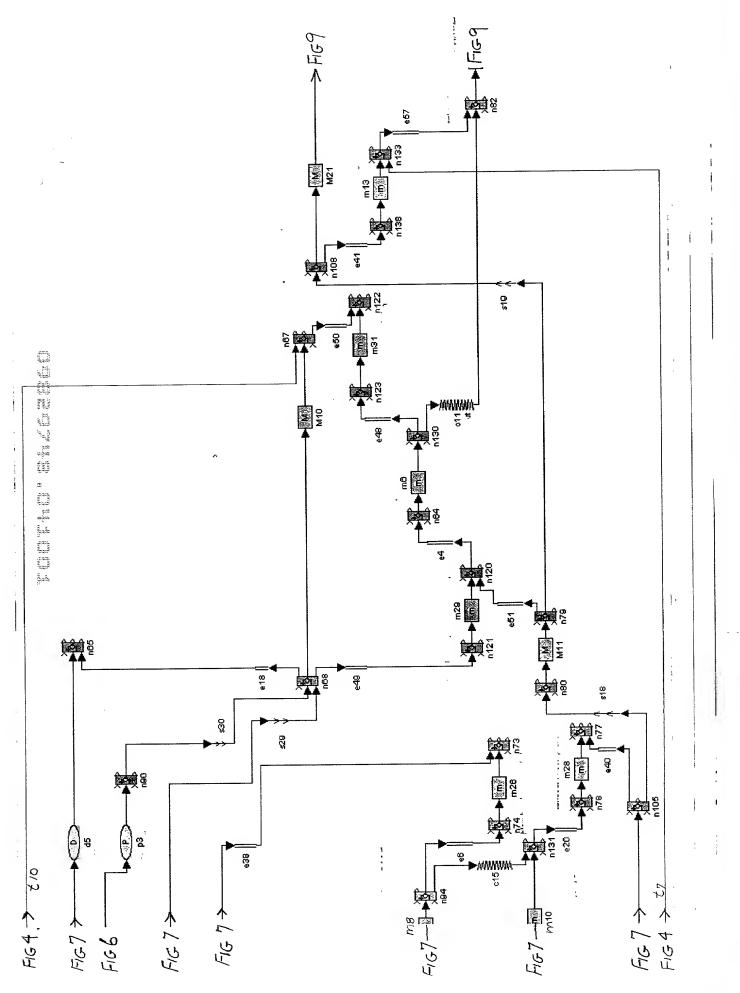
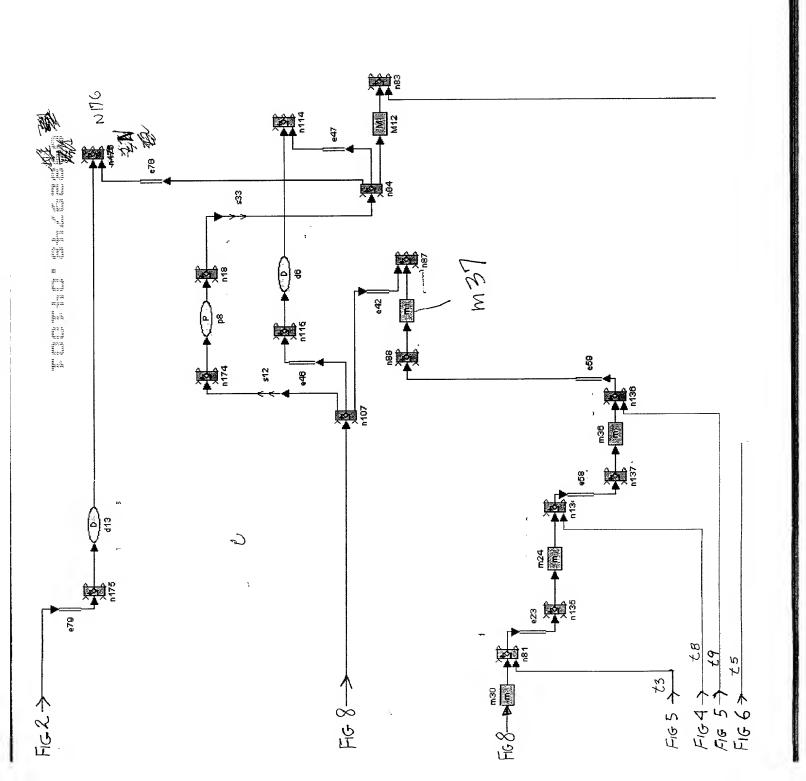
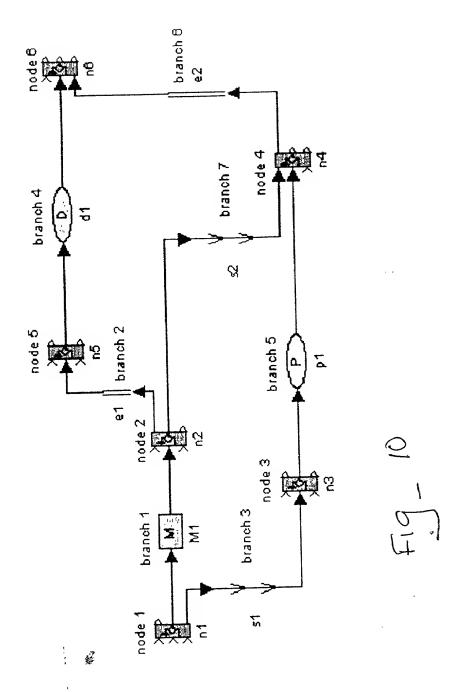


FIG 5



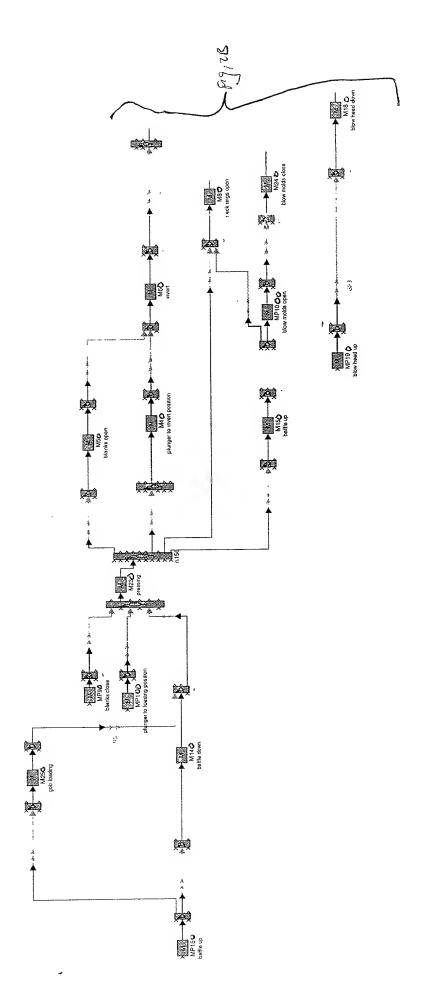




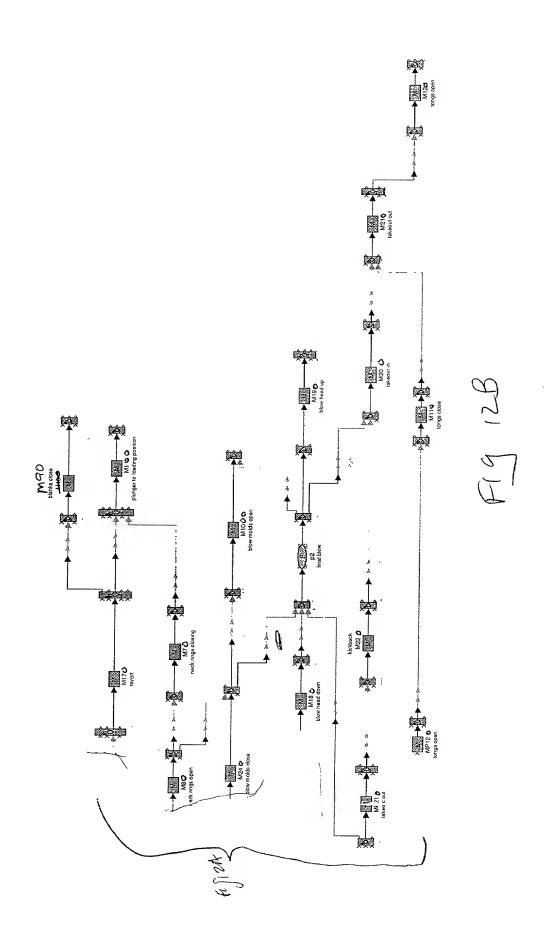


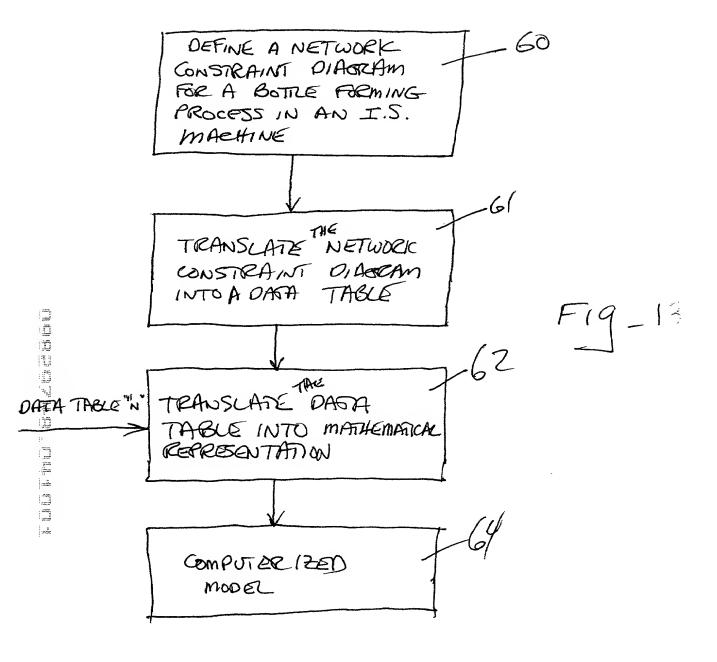
	G	Н	
Events	ON	OFF	
Gob Interceptor	334		14
Blanks Close	324		130
Blanks Open	130		321
Plunger Up	33	3	123
First Baffle	9		125
Plunger Down	127	7	327
Funnel		1	150
Settle Blow		1	1
Plunger Cooling	15	0	260
Invert	20	0	260
Neckring Open	274	.5	283
	28	32	172
	22	29	170
Mold Cooling			150
Blowhead	25	90	113
Final Blow	3	48	120
	1	37	197
	1	78	78
Take Out OUT	1	97	90
	Gob Interceptor Blanks Close Blanks Open Plunger Up First Baffle Plunger Down Funnel Settle Blow Plunger Cooling Invert Neckring Open Revert Molds Close/Open Mold Cooling Blowhead Final Blow Take Out IN Tongs Close	Events ON Gob Interceptor 334 Blanks Close 324 Blanks Open 130 Plunger Up 33 First Baffle 9 Plunger Down 127 Funnel 5 Settle Blow Plunger Cooling 15 Invert 20 Neckring Open 274 Revert 28 Molds Close/Open 22 Mold Cooling Blowhead 23 Final Blow 3 Take Out IN 1 Tongs Close 1	EventsONOFFGob Interceptor334Blanks Close324Blanks Open130Plunger Up33First Baffle9Plunger Down127Funnel1Settle Blow1Plunger Cooling150Invert200Neckring Open274.5Revert282Molds Close/Open229Mold Cooling10Blowhead290Final Blow348Take Out IN137Tongs Close178

F19-= 11



FIG







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F19-14

